

## AMENDMENTS TO THE SPECIFICATION

At page 2, first paragraph of the application, please amend the specification of the disclosure to read:

These round and non-round disc-shaped blanks are usually formed in a reciprocating press by telescopically moving an annular die cut ring about the outer cut surface of a blank and draw die in a downward press movement which shear the blank disc from the sheet material being moved therebetween. The alignment of the cut ring and blank and draw die is not a great problem where a round disc-shaped blank is produced. However, the proper alignment of the major and minor ~~axis~~ axes of the cut ring with respect to those of the blank and draw die is critical when producing a non-round disc-shaped blank due to the extremely close tolerances, generally 0.001 inches, between the shearing surfaces for forming the non-round disc blank. Thus, the alignment of these two components is critical when the cut ring telescopically moves beyond the blank and draw die, which is usually fixed on the base of the press, during a downstroke of the press component, to form a non-round blank.

At page 3, third paragraph of the application, please amend the specification of the disclosure to read:

One aspect of the invention includes providing a pair of precision-shaped openings in telescopically engageable cut ring and blank and draw die, which when accurately axially aligned with the axis of the press, insures that the major and minor ~~axis~~ axes thereof are accurately aligned to enable the cut ring and blank and draw die to form non-round blank-shaped discs for subsequent forming into container components

At page 8, first full paragraph of the application, please amend the specification of the disclosure to read:

Openings 42 and 43 are formed in peripheral portions 47 and 52 of members 25 and 30 respectively, and preferably have a rectangular-shaped configuration and extend inwardly from the peripheral edges 44 and 50 thereof so as to slidably receive an alignment key indicated generally at 60, therein. In accordance with the invention, key 60 aligns the major and minor ~~axis~~ axes of annular members 25 and 30 with respect to each other, in order to provide for the accurate engagement thereof for severing the non-round disc-shaped blanks from strip material 5. However, if desired, openings 42 and 43 could be formed completely

within peripheries 47 and 52 and have other configurations than rectangular without affecting the concept of the invention. However, the preferred configuration is rectangular, as shown in the drawings, providing a notch configuration having open ends 42A and 43A, respectively, enabling key 60 to be slidably inserted therein as discussed further below.

At page 9, first paragraph of the application, please amend the specification of the disclosure to read:

Openings 42 and 43 are accurately positioned with respect to their major and minor ~~axii axes~~ and to each other so that when in spaced vertical axial alignment in the press, the respective ~~axii axes~~ align with each other. In the preferred embodiment, openings 42 and 43 may be aligned with the major ~~axii axes~~. However, this alignment can be changed without affecting the invention, i.e. they could align with the minor ~~axii axes~~ or be offset equally therefrom, so long as the two openings are located the same with respect to the major and minor ~~axii axes~~.

At page 10, first full paragraph of the application, please amend the specification of the disclosure to read:

Initially both members 25 and 30 are mounted in position on the press by their respective attachment bolts 28 and 33, with openings 42 and 43 being generally axially aligned with each other, that is, one is spaced above the other along the vertical or longitudinal axis of the press. Since openings 42 and 43 are accurately positioned with respect to the non-round blank forming edges 27A and 58, such as being in alignment with the major ~~axii axes~~ D1 and D3 as shown in Figs. 2 and 3, this initial alignment will insure that the major and minor axis of the two members are generally in alignment with each other. Next, one of the members, preferably upper cut ring 25, is secured in position by tightening of bolts 28. Next, key 60 is slidably inserted in the generally aligned and spaced openings 42 and 43, as shown in Figs. 5 and 6, and blank and draw die 30, which is loosely mounted in its position by bolts 33, is slightly rotated manually until key 60 firmly seats within the spaced openings. Due to the very close tolerances of 0.001 inches between key 60 and the walls forming openings 42 and 43, this will insure that the same close tolerances is provided between cut edges 27A and 58 when members 25 and 30 are telescopically engaged. After key 60 has been firmly seated within the openings by slight rotation of member 30, bolts 33 are then securely tightened which will maintain members 25 and 30 in correct axial alignment with each other for subsequent forming of the non-round blank discs.

At page 11, first full paragraph of the application, please amend the specification of the disclosure to read:

Due to the mounting of members 25 and 30 with usual machine bolts which have a manufacturing tolerance of 1/32 inches, this would not provide the extreme accurate alignment required of the major and minor ~~axis~~ axes if members 25 and 30 were bolted in position without the use of key 60. Even though these differences are relatively slight, the 1/32 inch manufacturing tolerances in the bolts would not provide for the required close tolerance of 0.001 inch between the mating cut edges of members 25 and 30. After bolts 33 are tightened, key 60 is easily slidably removed from between the spaced members 25 and 30 in an outward direction perpendicular to the vertical axis of the press.